



Dart Aerospace Ltd.
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Canada

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Handwritten signature

D135-751-011
Job Sheet 176930



Part No: D135-751-011

Job Qty: 1 ea

Part Name: Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/3/18

Job Tracking No:

Due Date: 5/23/18

Handwritten: 6/13/18 TW

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG DSI 9661 REV A, D3507 REV D IPP Rev:A 44353 New Issue JLM IPP Rev:B 06-12-18 As per Rev B
JLM IPP Rev:C 07-12-11 ECN 1036 as per revB DD IPP Rev D 08.11.04 Added DT9431 to sequence 5 EC
verf DD IPP Rev E 10.02.22 per PAR 09-043 EC verified: DD IPP Rev:F 10.06.09 remove seq110 DD verf:EC
IPP Rev G 10.09.17 added D3507-1-bent EC verified:DD IPP REV:H 13.12.11 ECN13-619/ CHG002 DD
VERF:JLM

Ship Via:

Bill of Materials



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Container No: S075397



Part: D135-751-011

Job No: 176930

Serial No/Batch: S075397

Revision:

Inspector:

Date: 05/29/18

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/23/18	0.00	0.00	Start Up Skid tubes-1		BE
120	Skid tubes	1 pcs		5/23/18	0.00	0.80	Skid tubes-1		BE DAS
140	QC	1 pcs		5/23/18	0.00	0.00	QC5		38
150	HandFinish	1 pcs		5/23/18	0.00	0.33	HandFinish1		SA 18-06-04
160	QC	1 pcs		5/23/18	0.00	0.00	QC7-1		BE
170	Skid tubes	1 pcs		5/23/18	0.00	1.00	Skid tubes-1		BE DAS
180	QC	1 pcs		5/23/18	0.00	0.00	QC10		38
185	HandFinish	1 pcs		5/23/18	0.00	0.10	HandFinish6		SA 18-06-12
187	QC	1 pcs		5/23/18	0.00	0.00	QC7-1		BE
190	Skid tubes	1 pcs		5/23/18	0.00	0.77	Skid tubes-1		BE
200	QC	1 pcs		5/23/18	0.00	0.00	QC5		SA 18-6-13
210	HandFinish	1 pcs		5/23/18	0.00	0.08	HandFinish2		SA 18-06-13
220	SprayPaint	1 pcs		5/23/18	0.00	0.25	Spray Paint		SA 18-06-13
230	QC	1 pcs		5/23/18	0.00	0.00	QC14		SA 18-06-14
260	HandFinish	1 pcs		5/23/18	0.00	0.74	HandFinish4		BE 18-06-14
270	QC	1 pcs		5/23/18	0.00	0.00	QC5		38
280	Packaging	1 pcs		5/23/18	0.00	0.00	Packaging1-1		SA 18-06-15
290	QC	1 pcs		5/23/18	0.00	0.00	QC4		SA 18-06-15
295	DC	1 pcs		5/23/18	0.00	0.00	DC		SA 18-06-15
300	Packaging	1 pcs		5/23/18	0.00	0.00	Packaging3		SA 18-06-15
310	QC21-FG	1 Ea		5/23/18	0.00	0.00	QC21		SA 18-06-15

Part Op 120 - 1-Cut Aft end as per dwg D3507 3-Drill Aft & Fwd Cap holes using DT8678 & DT8901 4-Location DT8870 & Drill Descriptions: Ground wire hole on top of Tube. 6-Locate DT8870 with #30 cleco in Ground wire hole ,then Pilot Drill all X-Bolt holes using #30" drill. ****DO NOT OPEN AFT CAP HOLES***** 7-Open crossbolt holes to 0.3125" (3 per side). Drill pilot holes for wearplates using Dt8868, Use DT8892 FOR REAR WEARPLATE HOLES. 8-Open six rear wearplate holes using DT8892. Open all wearplate holes to 0.297" 9-Open ground wire hole .297" section E-E 10-Open Aft & Fwd Cap holes using .208" drill. 11-Bore out aft end of tube as per Dwg D3507 & Detail "B". 12- Section G-G holes must be laid out manually, open to #30. 13-Deburr holes.

170 - 1-Open X-Bolt holes to .375" (1 Places) & .500"(2Places) as per Dwg D3507. and section G-G to .750" (2 places) 2-Counter Sink X-BOLT holes as per Dwg D3507 3-Deburr and blow out chips from inside of tube. 4-Bond web as per Dwg D3507 & QSI 015 start time : 18-06-05 end time: 18-06-06 5-Weld x-bolt spacers as per Dwg D3507 and Detail C-C & D-D and G-G 7-Drill Rivet Holes as per Dwg D3507 Using Dt8871A&B 8-Deburr Rivet holes.

185 - RE-ALODINE ONLY

190 - 1-Rivet D3506-1/-3 as per Dwg D3507.

210 - Touch-up alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

220 - 1- Apply Primer as per QSI 005 4.2.1.3.3 and dwg A/R Primer Batch: 138747 2- Paint two coats of White paint as per QSI 005 4.2 and dwg A/R Paint Batch: 138863

260 - 1- Install Wearplate & Ground Wire inserts as per Dwg D3507. 1-Inspect for Foreign objects 2-Install Fwd & Aft caps as per Dwg D3507 And Detail "A" & "B" 3-Install Wearplates as per Dwg D3507 , Note:Install (1) Bolt and (1) washer on Ground Wire insert on top of tube Do not Install Scews where indicated on Dwg(Note #6) 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube 5- Wing Walk as per Dwg D3507 and QSI 005 4.4 Batch: _____

295 - Photocopy bluefile & type labels per PPP D135-751-011 CHG002

300 - Identify and pack for shipping as per PPP D135-751-011 PPP Rev: _____

EXP.
SikaPlex
138787
DEC 22
2018
A/R
M136158

Fg.
sold

O-ring Lube M138843

Wing walk M138851

Sika Plex M138787

EXP 18%

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3507-1-BENT	Skidtube Assembly EC135	1 Ea (1 ea)	90-Start up Operation	5071373
D3504-1	Crossbolt Spacer	2 Ea (2 ea)	170-Skidtubes	5077412
D3504-3	Crossbolt Spacer	1 Ea (1 ea)	170-Skidtubes	8105604
D3504-5	Crossbolt Spacer	2 Ea (2 ea)	170-Skidtubes	5071543
D3505-1	Web	1 Ea (1 ea)	170-Skidtubes	5008521
D3506-1	Doubler	4 Ea (4 ea)	190-Skidtubes	F164752
D3506-3	Doubler	2 Ea (2 ea)	190-Skidtubes	8131267
MS20601-AD4W3	Rivet	12 Ea (12 ea)	190-Skidtubes	5066193-1
ALS4-1032-225	Rivnut	1 Ea (1 ea)	260-HandFinish	5058138
ALS7-1032-130	Rivnut	38 Ea (38 ea)	260-HandFinish	5045668
AN3C4A	Bolt	31 Ea (31 ea)	260-HandFinish	5068642
AN3C5A	Bolt	2 Ea (2 ea)	260-HandFinish	5057153
AN526C1032R10	Screw	2 Ea (2 ea)	260-HandFinish	5071664-2
D2965	Cap	1 Ea (1 ea)	260-HandFinish	5045482
D2965-3	Cap	1 Ea (1 ea)	260-HandFinish	F126369
D3492-1	Plug	4 Ea (4 ea)	260-HandFinish	5052900
D3492-3	Plug	4 Ea (4 ea)	260-HandFinish	5067012
D3492-7	Plug	2 Ea (2 ea)	260-HandFinish	F106110
D4918-047	Wearplate Aft	1 Ea (1 ea)	260-HandFinish	5036145
D4918-1	Wearplate Fwd	1 Ea (1 ea)	260-HandFinish	5007120
D4918-3	Wearplate Center Fwd	1 Ea (1 ea)	260-HandFinish	5036781
D4918-5	Wearplate Center Aft	1 Ea (1 ea)	260-HandFinish	5036789
NAS1149C0332R	Washer	33 Ea (33 ea)	260-HandFinish	5056493
NAS1611-007	O-Ring	2 Ea (2 ea)	260-HandFinish	F103697
NAS1611-010	O-Ring	4 Ea (4 ea)	260-HandFinish	5022098
NAS1611-013	O-Ring	4 Ea (4 ea)	260-HandFinish	5034467
AN3C4A	Bolt	8 Ea (8 ea)	280-Packaging	500533
D3512-041	Wearplate	2 Ea (2 ea)	280-Packaging	5060105
NAS1149C0332R	Washer	8 Ea (8 ea)	280-Packaging	504987

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D3507-1-BENT	1	1	0
170-Skidtubes	D3504-1	2	2	0
	D3504-3	1	29	0
	D3504-5	2	0	0
	D3505-1	1	2	0
190-Skidtubes	D3506-1	4	17	0
	D3506-3	2	14	0
	MS20601-AD4W3	12	1,071	0
260-HandFinish	ALS4-1032-225	1	5,474	0
	ALS7-1032-130	38	2,541	0
	AN3C4A	31	2,121	0
	AN3C5A	2	1,925	0
	AN526C1032R10	2	73	0
	D2965	1	89	0
	D2965-3	1	39	0
	D3492-1	4	104	0
	D3492-3	4	103	0
	D3492-7	2	45	0
	D4918-047	1	10	0
	D4918-1	1	9	0
	D4918-3	1	8	0
	D4918-5	1	9	0
	NAS1149C0332R	33	6,100	0
	NAS1611-007	2	296	0
	NAS1611-010	4	585	0
	NAS1611-013	4	381	0
280-Packaging	AN3C4A	8	2,121	0
	D3512-041	2	14	0
	NAS1149C0332R	8	6,100	0

003879

Part Specifications
Specifications could not be found.

Plex 5/3/18 10:03 AM dart.lacelle.linda